

62. The method of claim 22 further comprising providing  $V_t$  shift inducing material over the insulation layer.

63. The method of claim 29 wherein the barrier layer is formed on the first insulation layer.

64. The method of claim 36 wherein the barrier layer is formed on the insulation layer.

65. The method of claim 43 wherein the barrier layer is formed on the insulation layer.

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